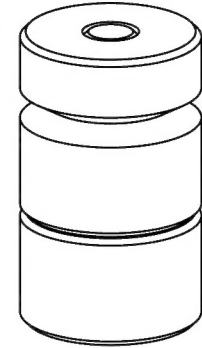
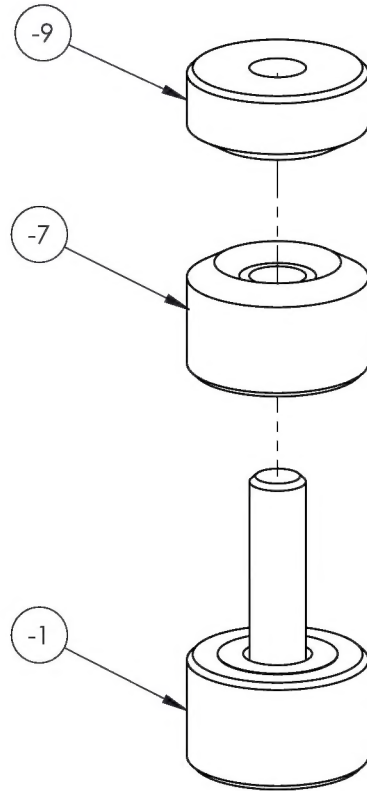


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	11/11/2016	DPD	JAG



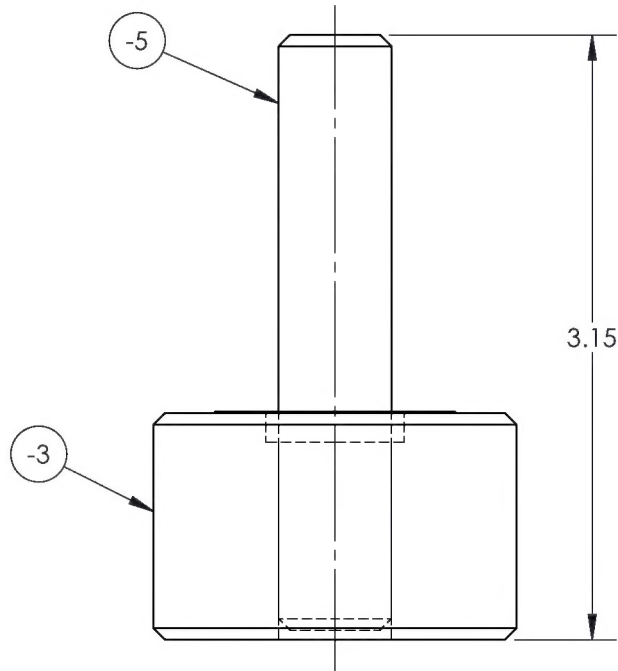
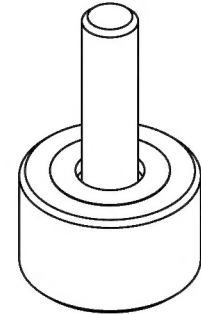
NOTE:
REF. AIRBUS T/N: 105-31781W5.

DART AEROSPACE																		
TITLE STAKING TOOL																		
DWG NO. RBE105-31781W5	REV 1																	
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 </td> </tr> <tr> <td>HEAT TREAT FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td></td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td></td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td></td> </tr> <tr> <td>APPROVED: GILBERT</td> <td></td> </tr> <tr> <td>SCALE 1:2</td> <td>DATE 8/19/2016</td> </tr> <tr> <td colspan="2">SHEET 1 OF 6</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	HEAT TREAT FINISH	SPEC	DRAWN BY: DUERFELDT	CHECKED: CLOUGH		OPPS APPR: ANDERSON		QA APPR: LINDSAY		APPROVED: GILBERT		SCALE 1:2	DATE 8/19/2016	SHEET 1 OF 6	
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CHECKED: CLOUGH																		
OPPS APPR: ANDERSON																		
QA APPR: LINDSAY																		
APPROVED: GILBERT																		
SCALE 1:2	DATE 8/19/2016																	
SHEET 1 OF 6																		

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	BASE ASSEMBLY			2
	1		-3		BASE	O1		3
	1		-5		BASE PIN	O1		4
			-7	1	PRESS	O1		5
			-9	1	STAKE	O1		6
	ASSY -1							

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



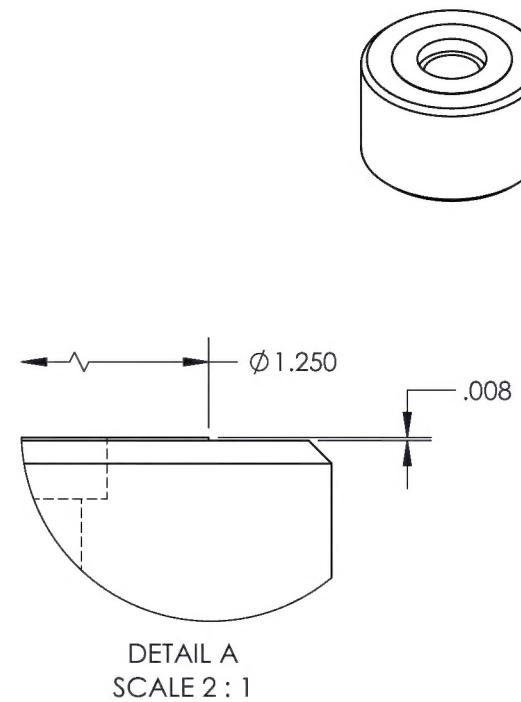
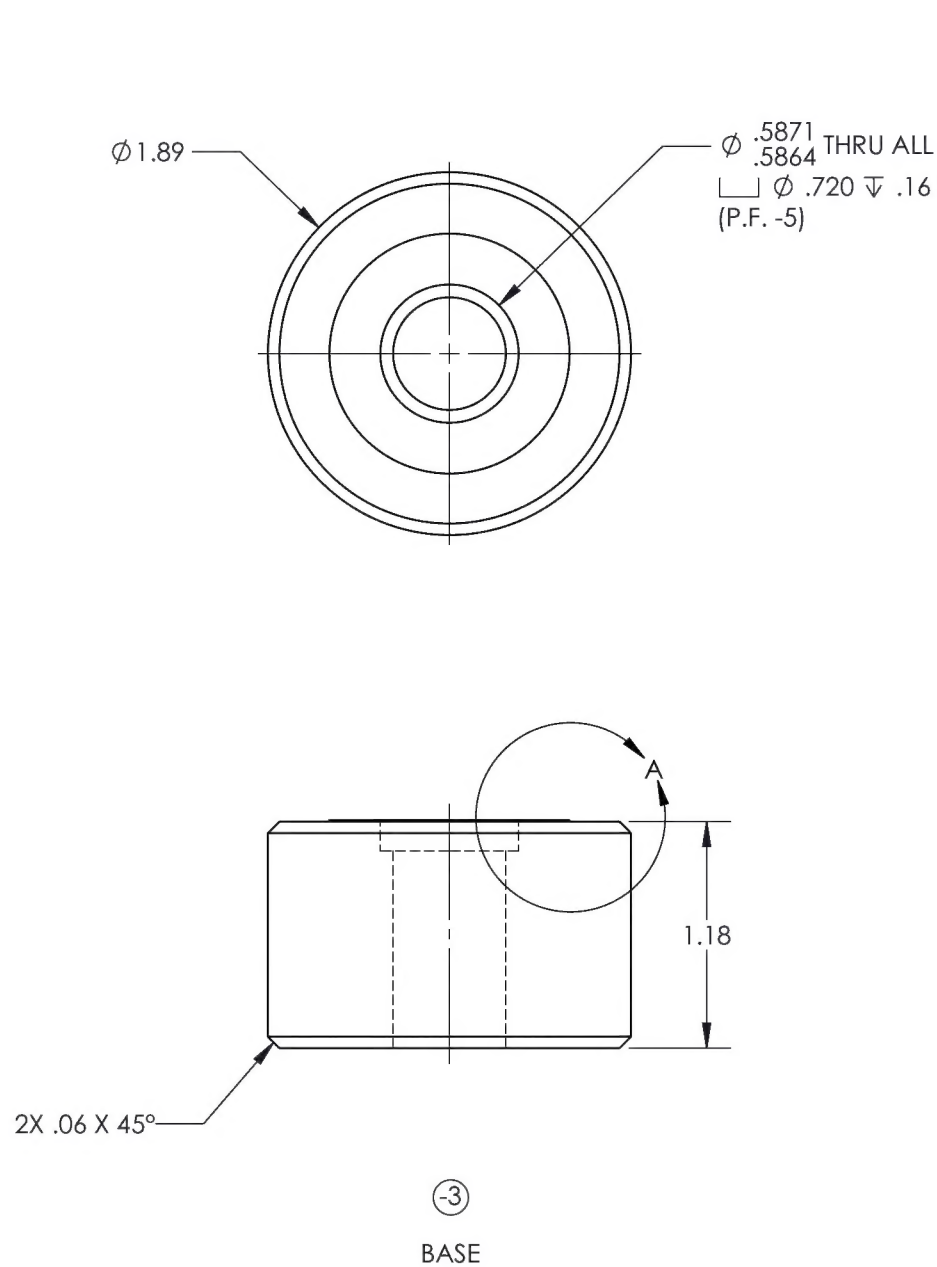
(-1)

BASE ASSEMBLY

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W5-1	REV 1
MAT'L HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H145
APPROVED: GILBERT	
SCALE 1:1	DATE 8/19/2016
SHEET 2 OF 6	

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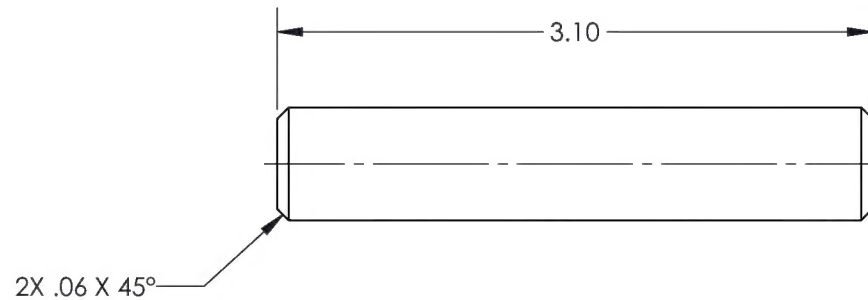
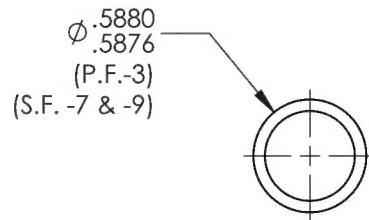
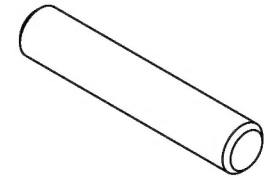
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W5-3	REV 1
MAT'L O1 HEAT RC 50-60 TREAT FINISH SEE -1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL H145
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 8/19/2016
SHEET 3 OF 6	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

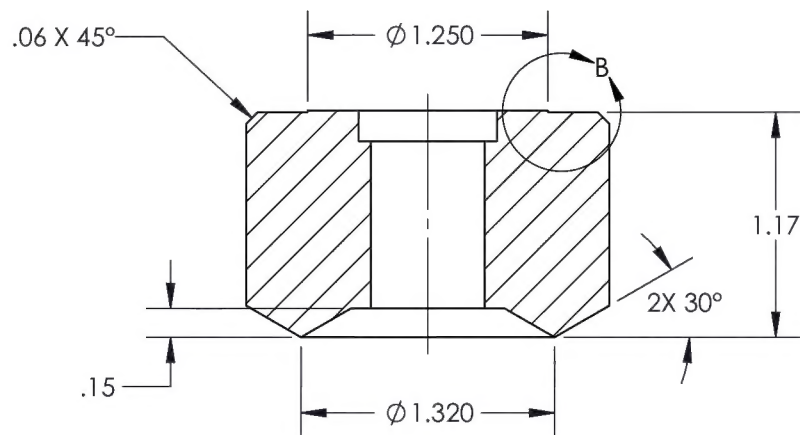
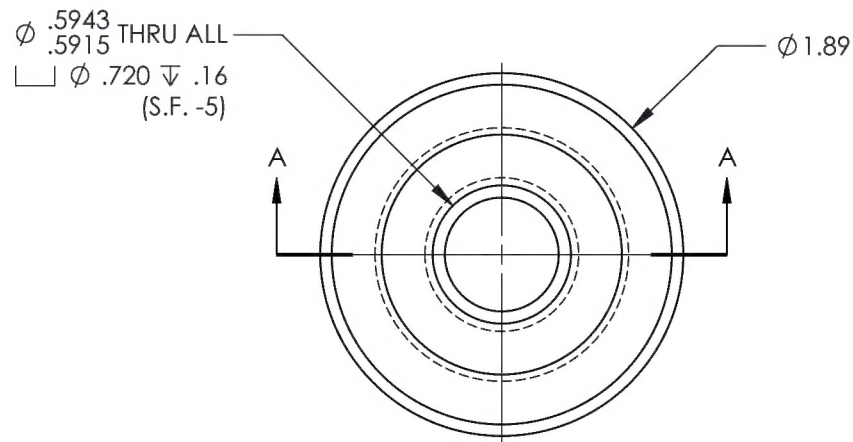


(-5)
BASE PIN

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W5-5	REV 1
MAT'L O1 HEAT RC 50-60 TREAT FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	USED ON MODEL H145
SCALE 1:1	DATE 8/19/2016
SHEET 4 OF 6	

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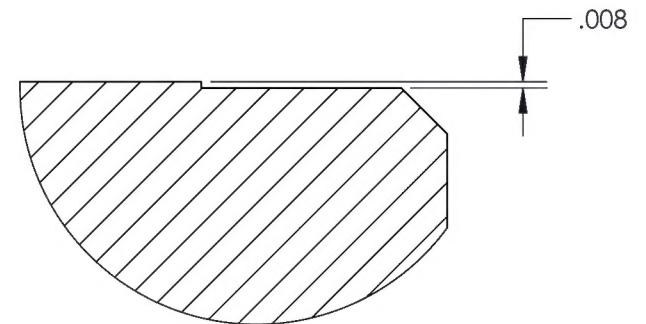
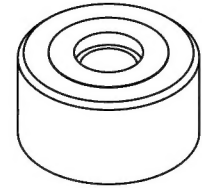
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A



PRESS

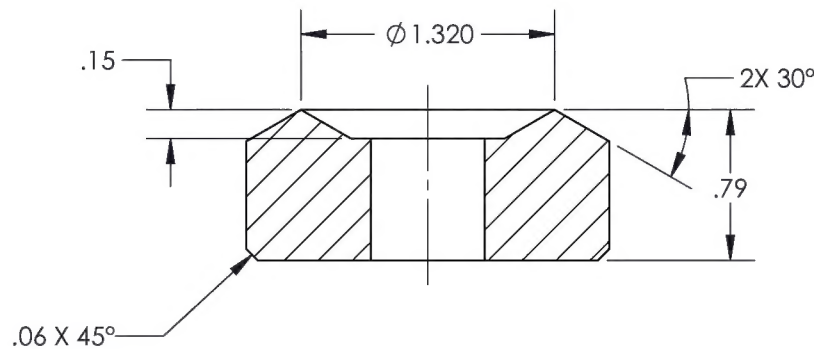
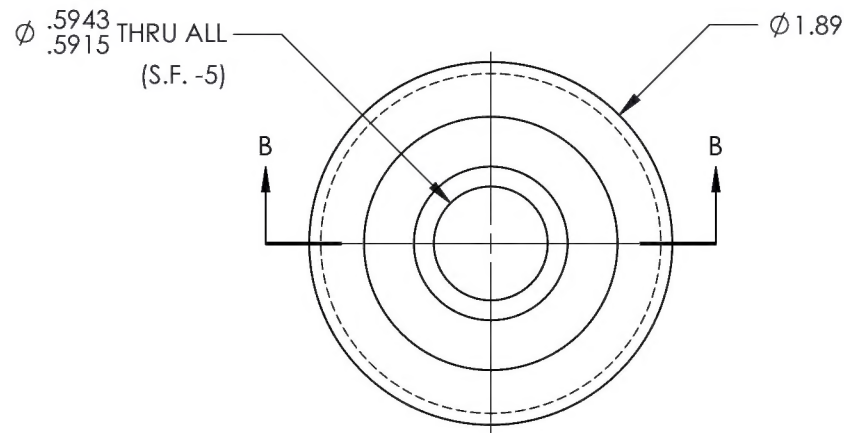
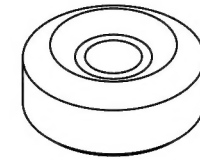


DETAIL B
SCALE 4 : 1

DART AEROSPACE	
TITLE STAKING TOOL	
DWG NO. RBE105-31781W5-7	REV 1
MAT'L O1 HEAT RC 50-60 TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H145
SCALE 1:1	DATE 8/19/2016
SHEET 5 OF 6	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SECTION B-B

⑨

STAKE

DART AEROSPACE																											
TITLE STAKING TOOL																											
DWG NO. RBE105-31781W5-9	REV 1																										
<table border="1"> <tr> <td>MAT'L O1</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT RC 50-60</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>TREAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH ZINC PLATE</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>SPEC ASTM B633 TYPE I SC 2</td> <td>.X ± .1 SURFACES = 125</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>SCALE 1:1</td> <td>DATE 8/19/2016</td> </tr> <tr> <td colspan="2">USED ON MODEL H145</td> </tr> <tr> <td colspan="2">SHEET 6 OF 6</td> </tr> </table>		MAT'L O1	UNLESS OTHERWISE SPECIFIED	HEAT RC 50-60	DIMENSIONS ARE IN INCHES	TREAT	.XXX ± .005 FRACTIONS ± 1/8	FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°	SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125	DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES	CHECKED: CLOUGH	.015 x 45° OR .015R	OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	QA APPR: LINDSAY	AFTER PLATING	APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	SCALE 1:1	DATE 8/19/2016	USED ON MODEL H145		SHEET 6 OF 6	
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